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5133426

D4634-141
Job Sheet 185361



006733

Part No: D4634-141

Job Qty: 1 ea

Part Name: Fwd, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/25/18

Job Tracking No:

Due Date: 12/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4634 REV G SHEET 7 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Document release DL VERIFIED BY: JLM IPP Rev C 13/07/09 Dwg Update DL verf: DD IPP Rev D Dwg Update 13/12/23 DL IPP REV E Dwg update 14/01/09 DL IPP Rev F Dwg. update 14/02/03 DL IPP Rev G Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/7/18	12/7/18	0.00	0.00	Start Up Small Fab		SMB
100	HandThermo	1 pcs	12/7/18	12/7/18	0.00	1.65	HandFinish4		SMB
110	Small Fab	1 pcs	12/7/18	12/7/18	0.00	1.47	Small Fab		SMB
120	QC	1 pcs	12/7/18	12/7/18	0.00	0.00	QC5		38
130	Packaging	1 pcs	12/7/18	12/7/18	0.00	0.00	Packaging3		SMB
140	QC21-SA	1 Ea	12/7/18	12/7/18	0.00	0.00	QC21		21 DEC 04 2018

Part Op 110 - Assemble as per Dwg D4634-141 Bond foam core to inside of panel 3M Scotch Weld 1300

Descriptions: Batch: m138775 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II. (see note 8) Batch # m138958 Expiry Date April 19 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer (see note 9) Batch m138691
120 - QC5- Inspect part completeness to step on W/O
130 - Identify as per dwg & Stock Location:
140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4634-1 fg 234	Fwd, Center Ceiling Panel	1 Ea (1 ea)	90-Start up Operation	5131079
D4636-5 ST 108	Bracket	1 Ea (1 ea)	90-Start up Operation	5004455
D4647-5 mf 004	Doubler	1 Ea (1 ea)	90-Start up Operation	5103352
D4664-5 mf 004	Spacer 5033886	6 Ea (6 ea)	90-Start up Operation	50339252
D4712-1 mf 004	Bracket	1 Ea (1 ea)	90-Start up Operation	50339253
D4732-15 mf 005	Label	1 Ea (1 ea)	90-Start up Operation	5104125
D4732-19 mf 005	Label	1 Ea (1 ea)	90-Start up Operation	5008995
D5021-1 fg 236	Foam, Center Panel, Fwd	1 Ea (1 ea)	90-Start up Operation	5123623
MPNY-750S-9-C ST 570	Mounting Pad	7 pcs (7 ea)	90-Start up Operation	fm130423-1
MS20426AD3-4 64006	Rivet	4 Ea (4 ea)	90-Start up Operation	fm136444-2
MS20426AD4-6 64007	Rivet	2 Ea (2 ea)	90-Start up Operation	5093088-1
MS21059L08 ST 300	Nut	2 Ea (2 ea)	90-Start up Operation	5129976

CCR26455-3-03 X4

5099729

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
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90-Start up Operation

D4634-1	1	2	0
D4636-5	1	39	0
D4647-5	1	1	0
D4664-5	6	21	0
D4712-1	1	17	0
D4732-15	1	12	0
D4732-19	1	15	0
D5021-1	1	0	0
MPNY-750S-9-C	7	126	0
MS20426AD3-4	4	4,602	0
MS20426AD4-6	2	1,909	0
MS21059L08	2	138	0

Part Specifications

Specifications could not be found.

Plex 10/25/18 12:52 PM Dart.lajeunesse.marie

UNITED STATES OF AMERICA
Fwd, Center Ceiling Replacement Panel Assembly
PART NO: D4634-141
Serial No/Batch: S133426
Revision:
Operation:
Change No:

Packaging

Mfg Date: 11/29/18
Job No: 185361

